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D2721-042
Job Sheet 206755



Part No: D2721-042

Job Qty: 4 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: High

Job Created: 2/7/20

Job Tracking No:

Due Date: 2/12/20

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	4 pcs			0.00	1.00	Large Fab - 1		<i>SL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	4 pcs			0.00	8.29	Large Fab - 1 - B4B		<i>SL</i>
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
120	QC 9	4 pcs			0.00	0.00	QC 9 - 10		DAS 43 9-80
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		

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			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
160 Large Fab - Steps - 3 - B4B	4 pcs	0.00 8.29	Large Fab - 1 - B4B	<i>SL</i>
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 9	4 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	DAS
			QC 9 - 43	43
			QC 9 - 50	9-89
			QC 9 - 9	
180 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	DAS
			QC 5 - 49	43
			QC 5 - 51	9-89
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
190 Handfinish - 1-2- Chemical- B4B	4 pcs	0.00 0.94	Handfinish - 1 - 1 - B4B	<i>BFB 20-02-12.</i>
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	

			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	4 pcs	0.00 0.58	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	00-02-13.
			Powdercoat - 4 - B4B	
210 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	BEB 20-02-14.
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
220 Handfinish - 3-1- WingWalk- B4B	4 pcs	0.00 0.94	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	BEB 20-02-14
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
230 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	

2388

DAS
59
9-89DAS
40
FEB 10 2020
9-89

240 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			Packaging 3 - 1 - B4B	803
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

Part Op 100 - Fabricate per Drwg - Cut D2721-2 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A

110 - Fabricate per Drwg - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10235 A followed by Jig DT10235B A/R AL Rod Batch: _____ Grind end cap welds flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1)

150 - QC3- Inspect Part Finish

160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush

170 - QC9- Inspect visual per QSI004- Fusion Welds

180 - QC5- Inspect part completeness to step on W/O

190 - Chemical Conversion Coat per QSI005 4.1

200 - White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum - START TIME: 8:35 OVEN TEMPERATURE: 320°

FINISH TIME: 9:05

210 - QC3- Inspect Part Finish

220 - Wing Walk as per dwg QSI005 4.4 Batch 5240464

230 - QC3- Inspect Part Finish

240 - Identify as per dwg & Stock Location:

250 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Steps - 1	S243427
D2734	Step End Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	S242135
D3461-1	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	① 5072100/S252481 ③
D3461-3	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	S253003
D3461-5	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	142383
D3461-7	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	S253029
MS20601-AD4W2	Rivet	4 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	S228472
D2734	Step End Plate	4 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	S242135

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	4	115	0
110-Large Fab - Steps - 2 - B4B	D2734	4	22	0
	D3461-1	4	25	0
	D3461-3	4	21	0
	D3461-5	4	35	0
	D3461-7	4	24	0
	MS20601-AD4W2	4	533	0
160-Large Fab - Steps - 3 - B4B	D2734	4	22	0

Part Specifications

Specifications could not be found.

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✓ 110# 14377



Container No: S254529



Part: D2721 - 042

Job No: 206755

Serial No/Batch: S254529

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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